

Work Order ID: **73061**

Thursday, August 25, 2011 7:12:26 AM

Page 1

Item ID: D2814

Accept

Revision ID:

Item Name: Strut

Start Date: 8/25/2011 Start Qty: 4.00

Required Date: 8/31/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID, Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2814

Rev A1

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012; i2-Deburr

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

1h00

OVEN TEMPERATURE:

1h30 FINISH TIME:

400°F

M120 222

SB 4

FF 12-02-15

(40)

4 Q (SP) 12/03/06

Work Order ID 73061



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Thursday, August 25, 2011 7:12:26 AM

Item ID: D2814

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 8/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4XQ m/L 12/03/06

140

Identify as per dwg & Stock Location: 265

0.00



Packaging

Memo

0.00

Packaging

12/3/06 SD (w)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/3/07 JD

12-03-4
4

Picklist Print

Thursday, August 25, 2011 7:12:23 AM

Page: 1

Work Order ID: 73061

Parent Item: D2814

Parent Item Name: Strut



Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C02.06.18 Added finishing level (Ref. ECN 435) [KJ]

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W!035 Purchased

No

100

f

62.3165

2

8.421053



④

FF 12-02-15

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

62.316478

115535

2.33

116720

1.66068

117598

58.325798

118702

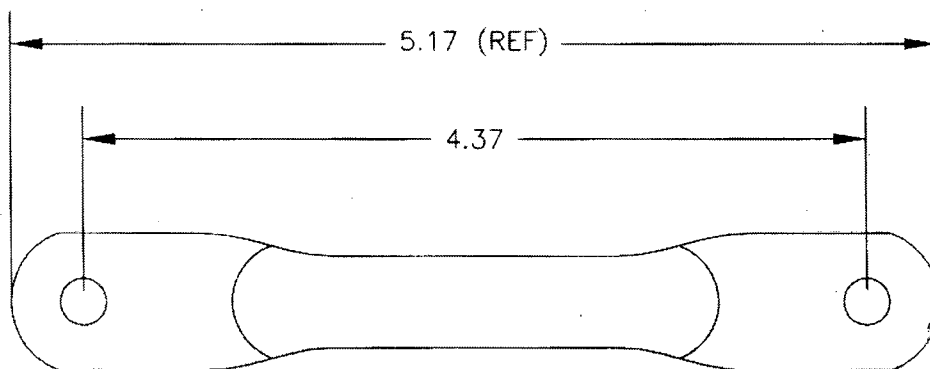
8.43



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2814	REV. A SHEET 1 OF 1
DATE 99.09.29		TITLE STRUT	SCALE 1:1
A	99.09.29	NEW ISSUE	
A1	CP # 02.07.20	ADD FINISH	

RELEASED
99.10.11 KE

W073061



PUNCH ENDS PER SPEC
CONTROL DRAWING D2727

NOTE:

MATERIAL: 304/316/318 SS, 0.50 OD x 0.035 WALL,
ENSURE SEAMLESS TUBING IS USED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.3) PER DART QSI 4.3 *[Handwritten mark]*